

Date: Tuesday, 11/13/2007 1:27:00 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PANEL	
Job Number	: 35667				
Estimate Number	: 10873				
P.O. Number	: N/A		Part Number	: D32455	
This Issue	: 11/13/2007	S.O. No. : N/A	Drawing Number	: D3245 REV B	
Prsh Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: 35047		Material	: N/A	
Written By			Due Date	: 12/5/2007	
Checked & Approved By			Qty:	10	Um: Each
Comment	: Est. A 04.07.07 New issue KJ/JLM Est Rev:b ECN 1052 07-10-31 DD verified by:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S22GA	304/316 .032 Sheet	
		Comment: Qty.: 0.8442 sf(s)/Unit Total : 8.4420 sf(s) 304/316 .032 Sheet	
		Batch: 105262 FB 07-11-16	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3245	
		Dwg Rev: B FB 07-11-16	(10)
		Prog Rev: B	
		2-Deburr if necessary FB 07-11-16	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		FB 07-11-16	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		S Ali 11/11/07 x10	cantex
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		Deburr if necessary	
		Form D3245-5 as per Dwg D3245/Identify as D3245-5	
		SB 07/11/20	

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/01/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:27:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 35667

Part Number: D32455

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

& Alu/20/10

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 79

AS 07/11/20 10x //

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 11/11/20

Job Completion



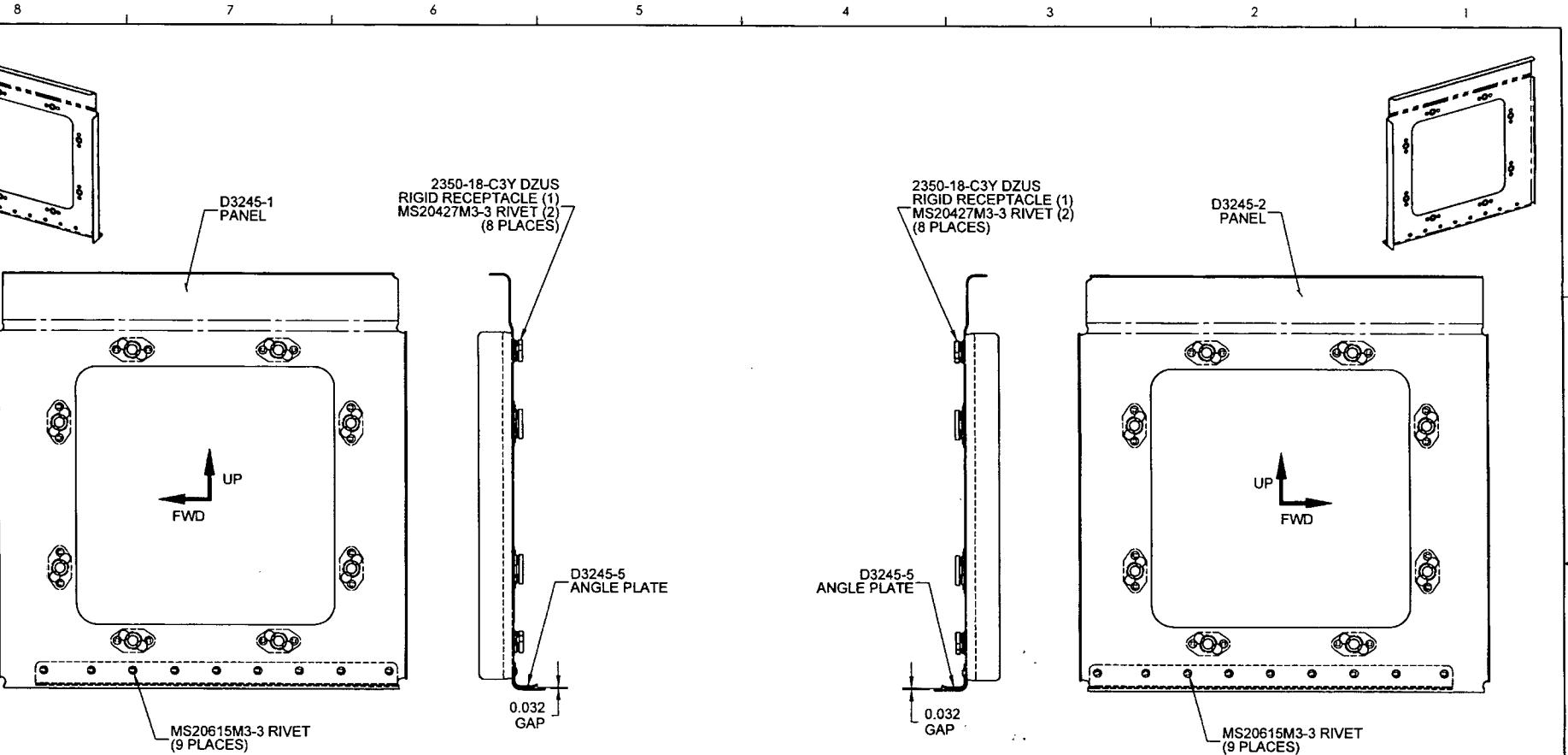
U 07.11.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3245-041 ACCESS PANEL ASSEMBLY

RELEASED
W 07.10.02

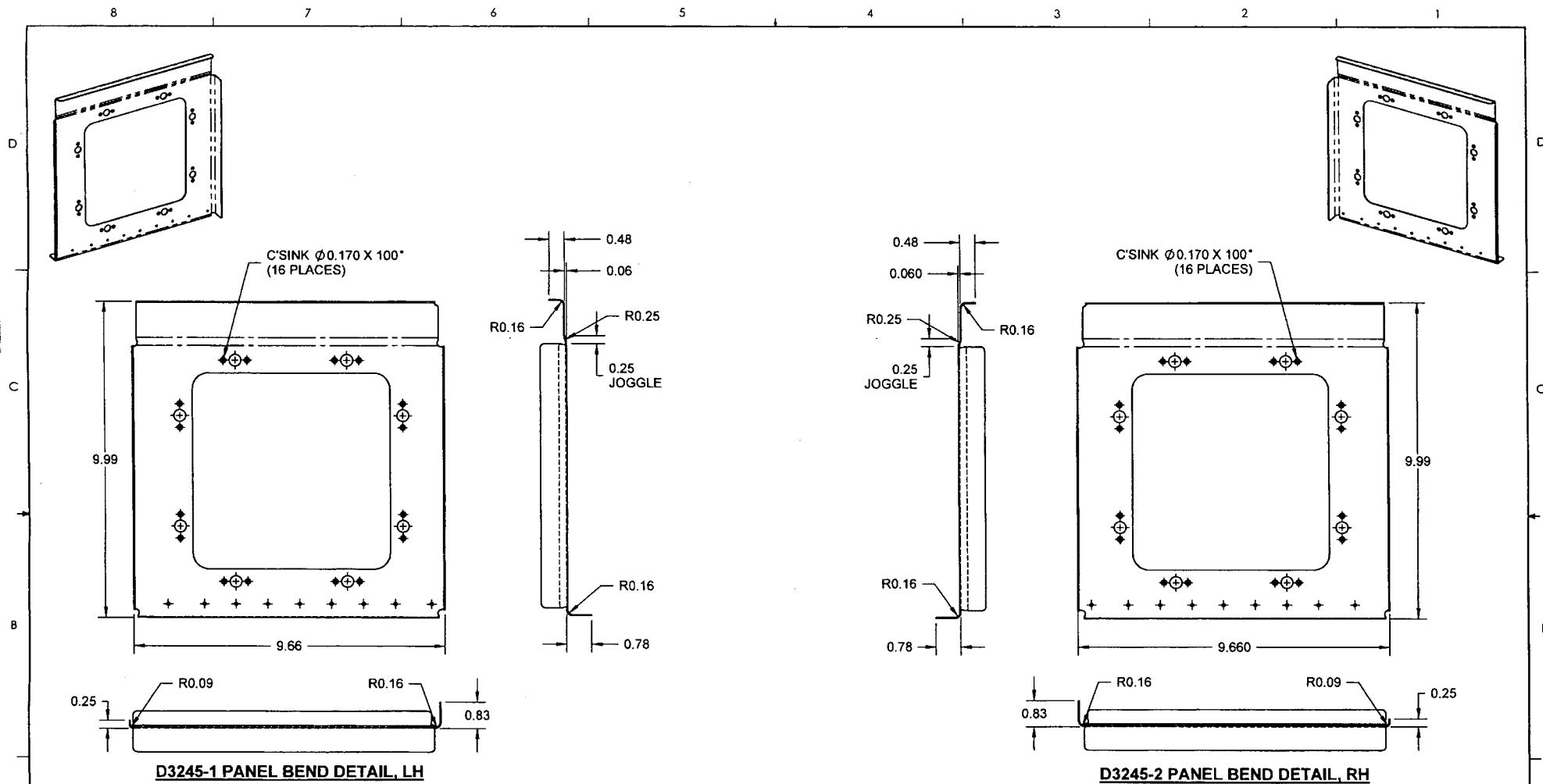
QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSEMBLY, LH
		D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.83 lbs

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 8

D3245-042 ACCESS PANEL ASSEMBLY

B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041/042: HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02			
A	NEW ISSUE	RF	04.01.27			
REV.	DESCRIPTION					
DESIGN	<i>PF</i>					
DRAWN	<i>AS</i>					
CHECKED	<i>PH</i>					
MFG. APPR.	<i>DS</i>					
APPROVED	<i>DP</i>					
DE APPR.	<i>SH</i>					
DATE	07.10.02					
DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA						
DRAWING NO. D3245 REV. B SHEET 1 OF 7						
TITLE: ACCESS PANEL ASSEMBLY SCALE: 12.5						
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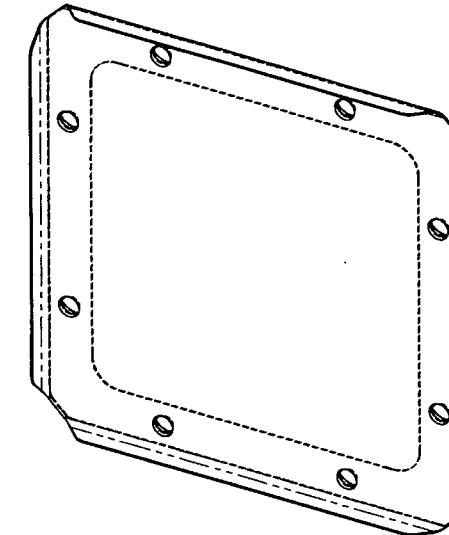
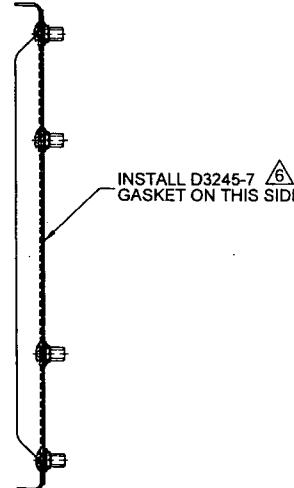
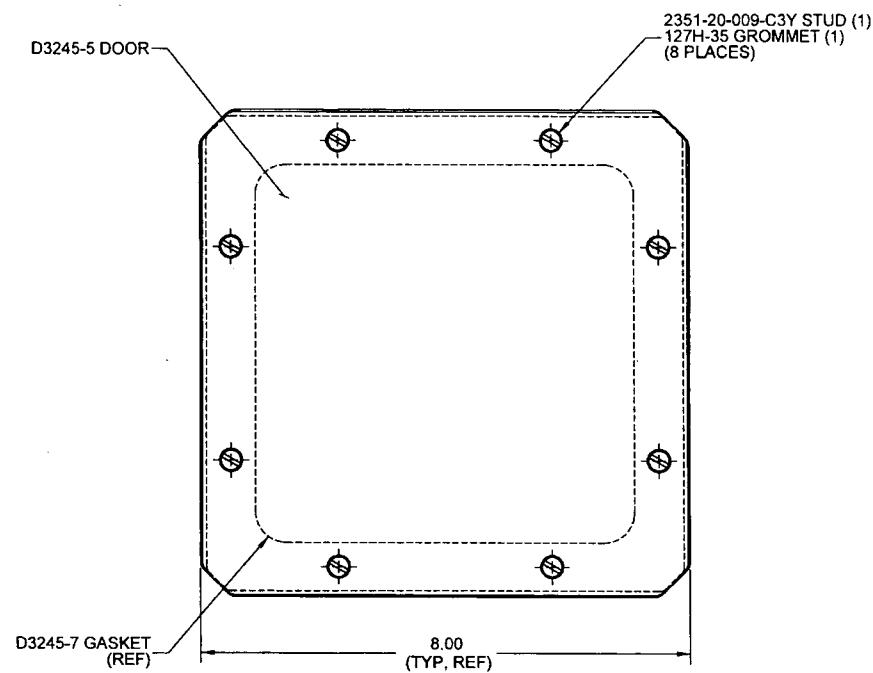
RELEASED
10-10-23

NOTES:
 1) MATERIAL: MAKE FROM D3245-1F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.70 lbs

NO.
 WORK ORDER #
 25067
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DESIGN	PF	DART AEROSPACE LTD
DRAWN	b	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	ND	D3245
APPROVED	10	REV. B
DE APPR.	SH	SHEET 2 OF 7
DATE	07.10.02	TITLE SCALE 1:3 ACCESS PANEL ASSEMBLY

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D3245-043 DOOR ASSEMBLY

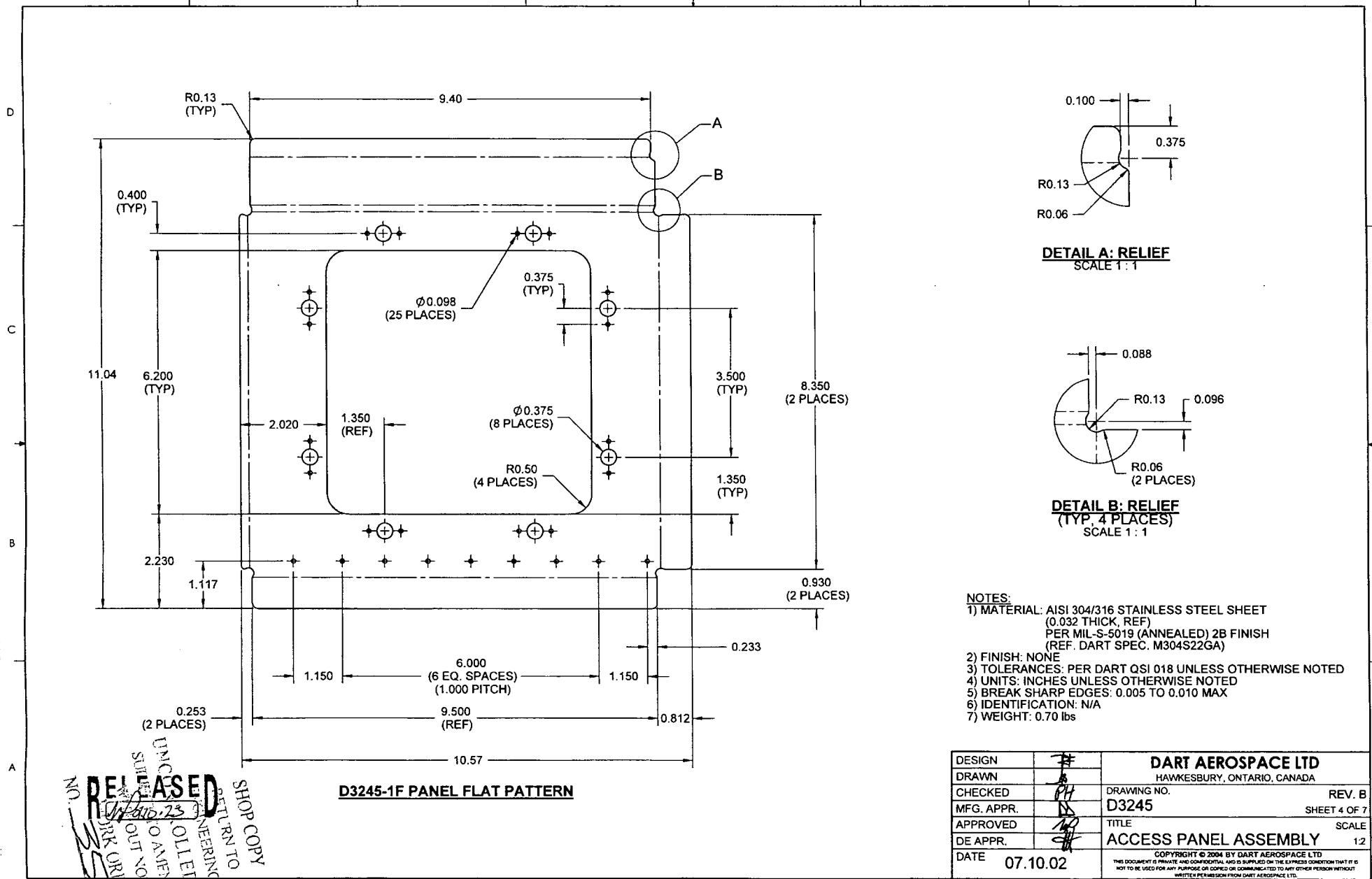
QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

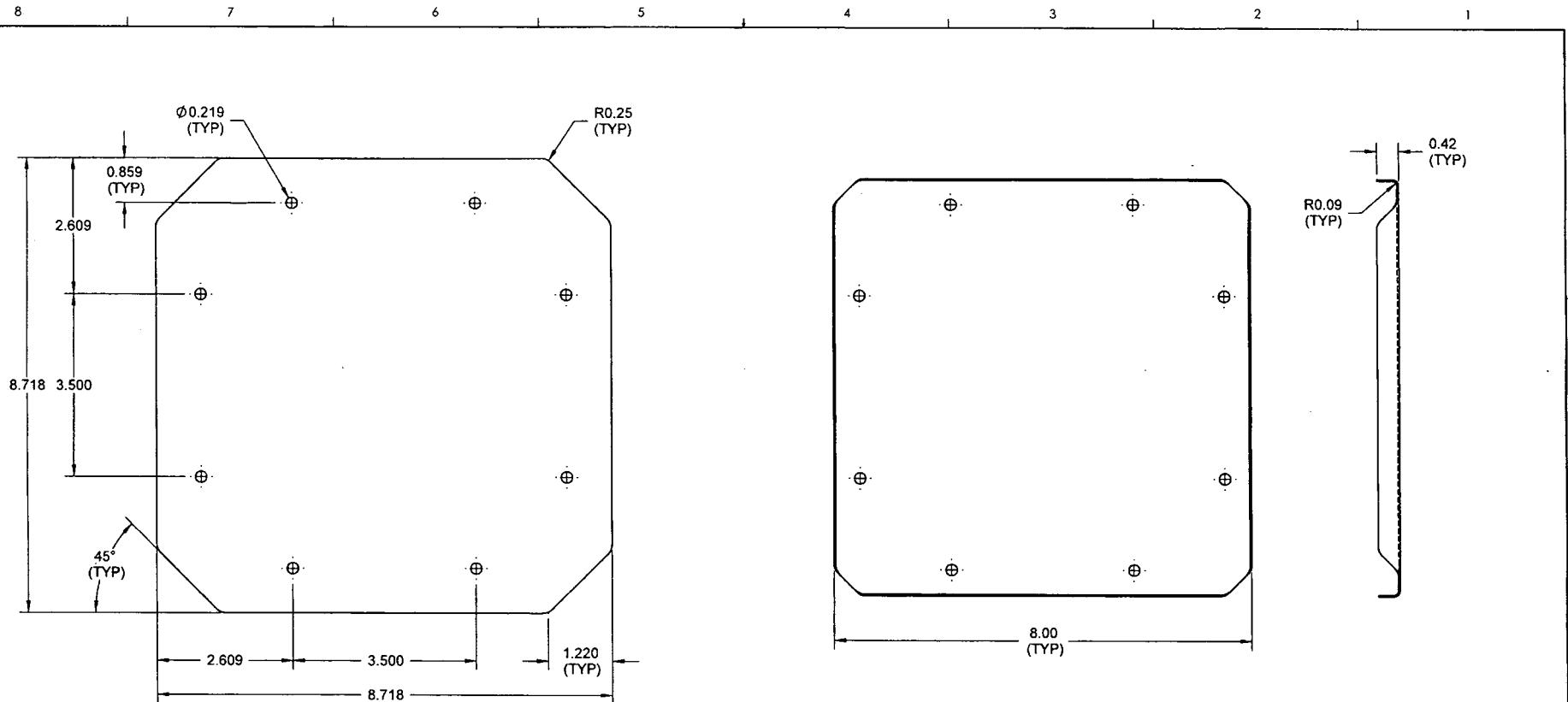
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

DESIGN	<u>PF</u>	DART AEROSPACE LTD	
DRAWN	<u>JA</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PH</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>DS</u>	D3245	SHEET 3 OF 7
APPROVED	<u>MP</u>	TITLE	SCALE
DE APPR.	<u>CH</u>	ACCESS PANEL ASSEMBLY	
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8 7 6 5 4 3 2 1



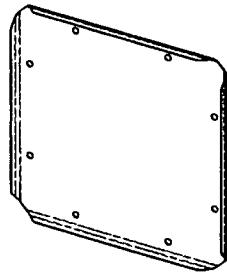


D3245-3F DOOR FLAT PATTERN

D3245-3 DOOR BENDING DETAIL

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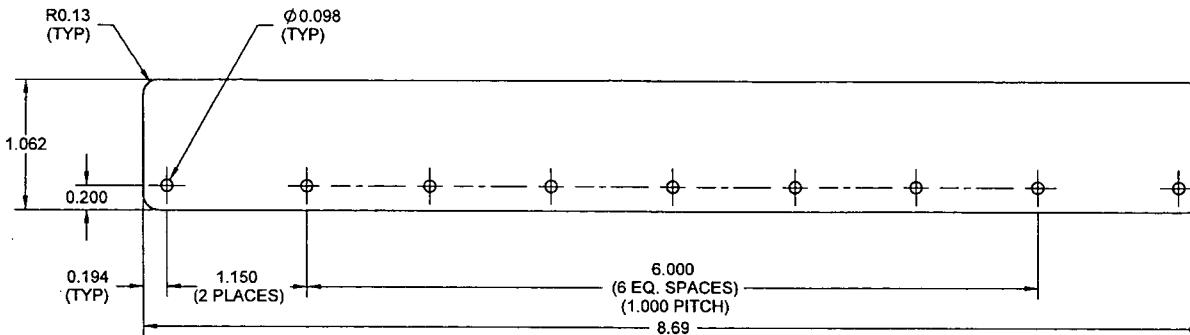
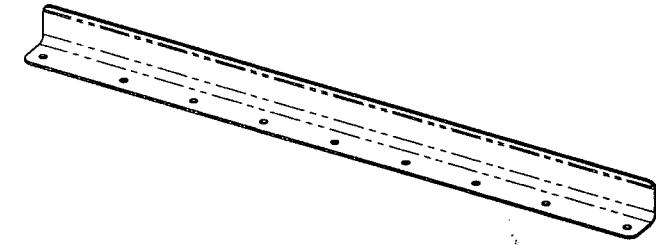
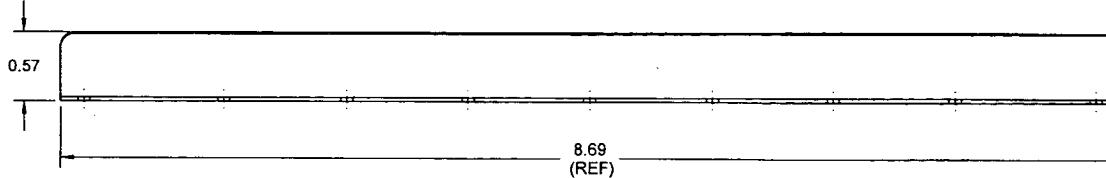
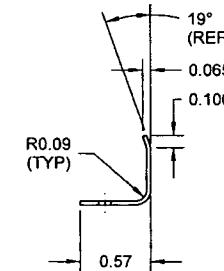
NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
 PER MIL-S-5019 (ANNEALED) 2B FINISH
 (REF. DART SPEC. M304S22GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.67 lbs



DESIGN	1#	DART AEROSPACE LTD			
DRAWN	1#	HAWKESBURY, ONTARIO, CANADA			
CHECKED	PH	DRAWING NO.			
MFG. APPR.	DS	D3245			
APPROVED	1#	REV. B			
DE APPR.	1#	TITLE			
DATE	07.10.02	SCALE			
ACCESS PANEL ASSEMBLY					
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**D3245-5 FLAT PATTERN****D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)**

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07.10.02

NOTES:

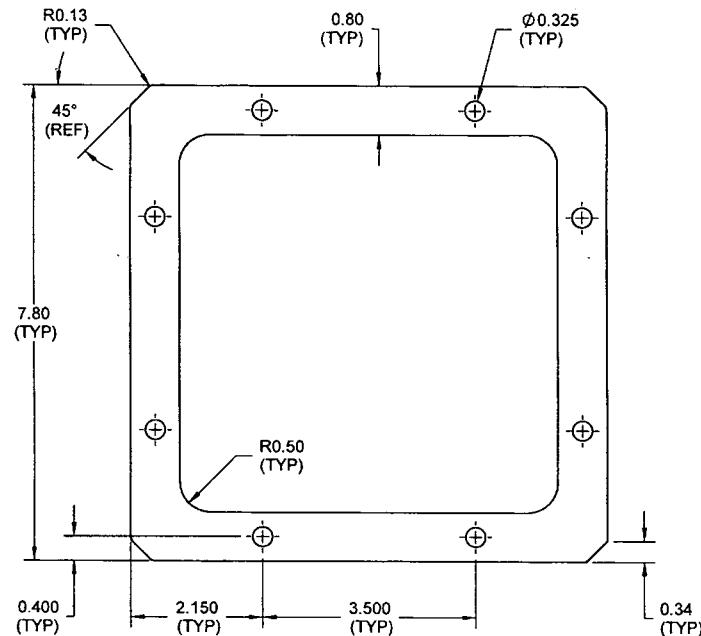
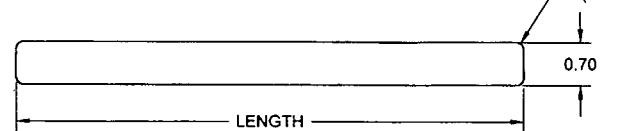
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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DESIGN	PF	DART AEROSPACE LTD	
DRAWN	AB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	
MFG. APPR.	DL	REV. B	
APPROVED	MP	D3245	
DE APPR.	HF	SHEET 6 OF 7	
DATE	07.10.02	TITLE	ACCESS PANEL ASSEMBLY
		SCALE	1:1

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8 7 6 5 4 3 2 1

**D3245-7 GASKET****D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

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07.10.02

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WORK ORDER

NOTES:
 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
 (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
 (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
 (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

DESIGN	<i>7F</i>	DART AEROSPACE LTD	
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	<i>D3245</i>
MFG. APPR.	<i>N</i>	REV. B	
APPROVED	<i>AP</i>	TITLE	ACCESS PANEL ASSEMBLY
DE APPR.	<i>AP</i>	SCALE	<i>1:2</i>
DATE	<i>07.10.02</i>	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

CART AEROSPACE LTD	Work Order:	35667
Description: PANEL	Part Number:	D3245-5
Inspection Dwg: D3245-5 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	u/
Date:	07-11-16	Date:	07/11/16	Date:	AA

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	